

Work Order ID 71199

Thursday, June 23, 2011 12:36:36 PM



Page 1

Item ID: D135-751-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube Installation

Start Date: 6/23/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/4/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: CY Date: 11/06/23 Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3492	C
D3507	Rev C

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D135-751-011 CHG001

DLR BG 11-7-26

B71199

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Cut Aft end as per dwg D3507

2-Deburr ends

3-Drill Aft & Fwd Cap holes using DT8678 & DT8901

4-Locate DT8870 & Drill Ground wire hole on top of Tube.

6-Locate DT8870 with #30 cleco in Ground wire hole ,then Pilot Drill all X-Bolt holes using #30" drill.****DO NOT OPEN AFT CAP HOLES****

7-Open crossbolt holes to 0.3125" (3 per side). Drill pilot holes for wearplates using Dt8868,Use DT8892 FOR REAR WEARPLATE HOLES.

8-Open six rear wearplate holes using DT8892.Open holes to 0.297"

9-Open Aft & Fwd Cap holes using .208" drill.

10-Bore out aft end of tube as per Dwg D3507 & Detail "B".

11-Open ground wire hole .297" section E-E

12- Section G-G holes must be laid out manually, open to #30.

13-Deburr holes.

1 0 BEU/07/19

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

(X)

(X)

1

0

8/24/20

BB 11/07/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

170

0.00



Skidtubes

0.00

Skidtubes

Memo

1-Open X-Bolt holes to .375"(2Places) & .500"(2Places) as per Dwg D3507 and Detail "F"

2-Counter Sink X-BOLT holes as per Dwg D3507

3-Deburr and blow out chips from inside of tube.

4-Bond web as per Dwg D3507 & QSI 015

A/R 241 Sike Flex Batch: 117516
Exp Date: 12/01/15
start time: 11:30am
end time: _____

DL 11/07/20

5-Weld x-bolt (D3504-1/-3) spacers as per Dwg D3507 and Detail C-C & D-D.

A/R AL ROD Batch: M112860

AE 11/07/21

6-Grind welds flush

7-Drill Rivet Holes as per Dwg D3507 Using Dt8871A&B

8-Deburr Rivet holes.

BB 11/07/21

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC10- Inspect visual per QSI004- ground welds	0.00							
QC	Memo	0.00							
Quality Control									
190	Skidtubes	0.00							
Skidtubes	Memo	0.00							
Skidtubes	1-Rivet D3506-1/-3 as per Dwg D3507.								
200	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

11.07.21

11/07/22

11 07 22 1

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

210

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

✓ Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

1 0 11-7-25

220

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

M117745.

Memo

0.00

Powder Coating

START TIME: 9:50

OVEN TEMPERATURE: 320°

FINISH TIME: 10:20

1 0 BL 11-7-25

230

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 0 11-7-25

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

260

0.00



HandFinishing

HandFinish

Memo

0.00

Hand Finishing

✓ 1- Install Wearplate & Ground Wire inserts as per Dwg D3507.

✓ 1-Inspect for Foreign objects

✓ 2-Install Fwd & Aft caps as per Dwg D3507 And Detail "A" & "B"

A/R 241 Sika Flex Batch: M117516
Exp Date: 15109

✓ 3-Install Wearplates as per Dwg D3507,

Note: Install (1) Bolt and (1) washer on Ground Wire insert on top of tube
Do not Install Sccws where indicated on Dwg(Note #6)

A/R 241 Sika Flex Batch: 16117516
Exp Date: 15109

✓ 4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube

A/R 55-o'ring lube batch: 11114189

✓ 5- Wing Walk as per Dwg D3507 and QSI 005 4.4

Batch: 11117863

1 0 24/04/25

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

270

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

11/7/25 07 25 ①

280

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/7/25 07 25 ①

290

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

11/7/25 07 25 ①

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

300

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D135-751-011

Location: _____

PPP Rev: 13

310

0.00



QC21 - Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

W. L. O. F. 26

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

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Page 1

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Parent Item: D135-751-011

Parent Item Name: Skidtube Installation



Start Date: 6/23/2011

Required Date: 7/4/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 06-06-21 New Issue JLM
 IPP Rev:B 06-12-18 As per Rev B JLM
 IPP Rev:C 07-12-11 ECN 1036 as per revB DD
 IPP Rev D 08.11.04 Added DT9431 to sequence 5 EC verified DD
 IPP Rev E 10.02.22 per pAR 09-043 EC verified by: DD IPP Rev:F
 10.06.09 remove seq110 DD verf:EC IPP Rev G 10.09.17
 added D3507-1-bent EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
ALS7-1032-130 		Purchased	No				Each	1,485.000		38			
Insert													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST282				1485					
				117717				1485		11 118386		138	
D3507-1-BENT 		Manufactured	No			120	Each	2.0000	1	1			
Skidtube Assembly EC135													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				LG				2					
				62291				1					
				62292				1					
D3504-1 		Manufactured	No			170	Each	6.0000	2	2			
Crossbolt Spacer													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				LG001				6					
				53742				6					

B 71200 ~1 8/24/19

B 71130 ~2 8/24/19

W/O:		WORK ORDER CHANGES					
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Parent Item Name: Skidtube Installation

Start Date: 6/23/2011

Required Date: 7/4/2011

Start Qty: 1.00

Required Qty: 1.00

D3504-3 Manufactured No

170 Each

26.0000

1 1



Crossbolt Spacer



BE 11/07/21

Location

Loc Qty

Loc Code

LG001

26

31232

6

53743

20

1

D3504-5 Manufactured No

170 Each

8.0000

2 2



Crossbolt Spacer



BE 11/07/21

Location

Loc Qty

Loc Code

LG001

8

53744

8

2

D3505-1 Manufactured No

170 Each

0.0000

1 1



Web



DH

D3506-1 Manufactured No

190 Each

47.0000

4 4



Doubler



11/07/20

BB

11/07/22

Location

Loc Qty

Loc Code

ST063

47

51789

47

4

D3506-3 Manufactured No

190 Each

87.0000

2 2



Doubler



BB 11/07/22

Location

Loc Qty

Loc Code

ST063

87

51790

87

2

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Start Date: 6/23/2011

Required Date: 7/4/2011

Start Qty: 1.00

Required Qty: 1.00

MS20601-AD4W3

Purchased

No

190

Each

2,846.000

12

12



Rivet



12

3B

11/07/22

Location

Loc Qty

Loc Code

ST321

2846

114538

2846

ALS4-1032-225

Purchased

No

260

Each

730.0000

1

1



Insert



u

11/07/25

Location

Loc Qty

Loc Code

ST282

730

110768

213

117717

517

x1

AN3C4A

Purchased

No

260

Each

2,494.000

31

31



BOLT



u

11/07/25

Location

Loc Qty

Loc Code

ST350

2494

117094

8

117313

2

117688

800

117795

500

117872

184

118012

500

118112

500

x3

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Start Date: 6/23/2011

Required Date: 7/4/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C5A Purchased No 260 Each 1,403.000 2 2
Bolt

Location	Loc Qty	Loc Code
FP-A	7	
115835	7	
ST350	1396	
116419	28	
116549	54	
117343	500	
117508	14	
117764	300	
117872	500	



1107125

AN526C1032R10 Purchased No 260 Each 245.0000 2 2
Screw

Location	Loc Qty	Loc Code
FP-B	107	
108062	107	
ST327	100	
114494	100	
ST328	38	
110049	38	



1107125

AN960C10L NAS1149C0332 Purchased No 260 Each 0.0000 33 33
washer



1118306



(x33) 1107125

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Shop Packet Print

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Start Date: 6/23/2011

Required Date: 7/4/2011



Start Qty: 1.00

Required Qty: 1.00

D2965	Manufactured	No	260	Each	25.0000	1	1
							<u>1107/25</u>
Cap, 105 Skidtube							



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP006	25	
<u>52057</u>	25	<u>X1</u>

D2965-3	Manufactured	No	260	Each	3.0000	1	1
							<u>1107/25</u>
Cap							



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP005	3	
50560	2	B71300
<u>52282</u>	1	<u>X1</u>

D3492-1	Manufactured	No	260	Each	68.0000	4	4
							<u>1107/25</u>
Plug							



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP	68	
69531	8	
<u>69819</u>	60	<u>X1</u>

D3492-3	Manufactured	No	260	Each	60.0000	4	4
							<u>1107/25</u>
Plug							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP	60	
69822	60	B70692
		<u>X4</u>

D3492-7	Manufactured	No	260	Each	0.0000	2	2
							<u>1107/25</u>
Plug							

D3492-047

B70901

X2 1107/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, June 23, 2011 12:36:34 PM

Work Order ID: 71199

Parent Item: D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 6/23/2011

Required Date: 7/4/2011

Start Qty: 1.00

Required Qty: 1.00

D3508-1 Manufactured No

260 Each

12.0000

1

1



Wearplate



HL 11/07/25

Location

Loc Qty

Loc Code

FP016

12

61020

12

D3508-3 Manufactured No

260 Each

4.0000

1

1



Wearplate



HL 11/07/25

Location

Loc Qty

Loc Code

FP021

4

38527

1

67489

3

D3508-5 Manufactured No

260 Each

6.0000

1

1



Wearplate



HL 11/07/25

Location

Loc Qty

Loc Code

FP021

6

67160

6

D3508-7 Manufactured No

260 Each

11.0000

1

1



Wearplate



HL 11/07/25

Location

Loc Qty

Loc Code

FP021

11

67159

5

67739

6

HL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, June 23, 2011 12:36:34 PM

Work Order ID: 71199

Parent Item: D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 6/23/2011

Required Date: 7/4/2011

Start Qty: 1.00

Required Qty: 1.00

D3558-1 Manufactured No

260 Each

12.0000

1

1



Gasket



11/07/25

Location

Loc Qty

Loc Code

FP014

12

42533

1

50925

11

D3558-3 Manufactured No

260 Each

6.0000

1

1



Gasket



11/07/25

Location

Loc Qty

Loc Code

FP014

6

67486

6

1371651

1

D3558-5 Manufactured No

260 Each

14.0000

1

1



Gasket



11/07/25

Location

Loc Qty

Loc Code

FP014

14

43244

1

50926

1

67485

12

D3558-7 Manufactured No

260 Each

16.0000

1

1



Gasket



11/07/25

Location

Loc Qty

Loc Code

FP014

16

67162

16

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, June 23, 2011 12:36:34 PM

Work Order ID: 71199

Parent Item: D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 6/23/2011

Required Date: 7/4/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1611-007

Purchased

No

260

Each

294.0000

2

2



O-RING



all 11/07/25

Location

Loc Qty

Loc Code

FP-A

294

103697

294

x2

NAS1611-010

Purchased

No

260

Each

214.0000

4

4



O-RING



all 11/07/25

Location

Loc Qty

Loc Code

FP

96

117460

16

118077

80

FP-A

118

110915

95

x4

115589

23

NAS1611-013

Purchased

No

260

Each

192.0000

4

4



O-RING



all 11/07/25

Location

Loc Qty

Loc Code

FP

187

117291

47

117887

140

x4

FP-A

5

116582

5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

* NOTE: Date & initial all entries

Picklist Print

Thursday, June 23, 2011 12:36:34 PM

Work Order ID: 71199

Parent Item: D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 6/23/2011

Required Date: 7/4/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C4A
BOLT

Purchased No

280 Each

2,494.000

8 8

Location

Loc Qty

Loc Code

ST350

2494

117094

8

117313

2

117688

800

117795

500

117872

184

118012

500

118112

500

AN960C10L
washer
D3512-1
Wearplate

NAS1149C0332
R

Purchased No

280 Each

0.0000

8 8

Manufactured No

280 Each

4.0000

12 2

Location

Loc Qty

Loc Code

ST500

4

70863

4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D3492-XX PLUG
(SEE TABLE)

NAS1611 O-RING
(SEE TABLE)

D3492-XXX PLUG PARTS LIST

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -053	PART NUMBER	DESCRIPTION
X							D3492-041	PLUG ASSEMBLY
	X						D3492-043	PLUG ASSEMBLY
		X					D3492-045	PLUG ASSEMBLY
			X				D3492-047	PLUG ASSEMBLY
				X			D3492-049	PLUG ASSEMBLY
					X		D3492-051	PLUG ASSEMBLY
						X	D3492-053	PLUG ASSEMBLY
1							D3492-1	PLUG
	1						D3492-3	PLUG
		1					D3492-5	PLUG
			1				D3492-7	PLUG
				1			D3492-9	PLUG
					1		D3492-11	PLUG
						1	D3492-13	PLUG
		1					NAS1611-005	O-RING
			1				NAS1611-007	O-RING
1							NAS1611-010	O-RING
						1	NAS1611-012	O-RING
	1						NAS1611-013	O-RING
					1		NAS1611-015	O-RING
				1			NAS1611-016	O-RING

NOTES:

1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

SHOP COPY
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT

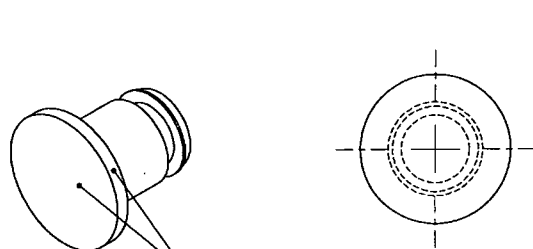
WITHOUT NOTICE
WORK ORDER

NO. 71199

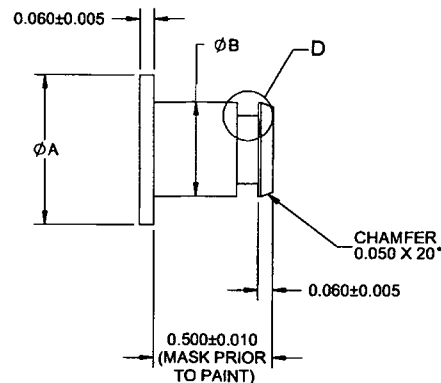
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2011-05-30

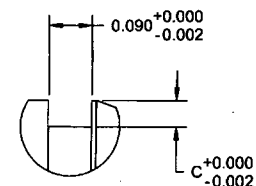
D	INCORPORATED DEO D3492-C-1. SHT 2 DIM C FOR -1 WAS 0.055. (SEE CART11-048)	AJS	11.05.24
C	ADD -049/-051/-053, CHANGE DRAWING FORMAT	PH	07.10.05
B	ADD -047, UPDATE DIM A FOR -045	PH	08.05.11
A	NEW ISSUE	PH	08.01.04
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>J.F.</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>AJS</i>	D3492	SHEET 1 OF 2
APPROVED	<i>AJS</i>	TITLE	SCALE
DE APPR.	<i>AJS</i>	PLUG	2:1
DATE	11.05.24	<small>COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



POWDER COAT THESE
FACES ONLY PER NOTE 2



D3492-XX PLUG



DETAIL D

D3492-XX PLUG MACHINING DETAILS

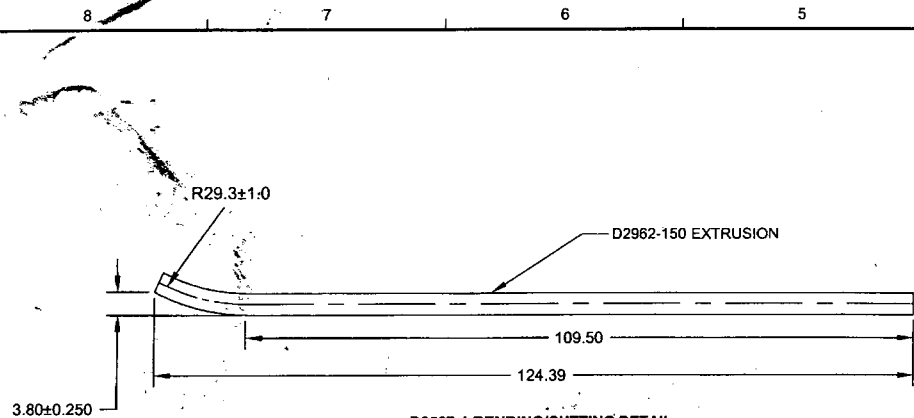
P/N	A	B	C	MATERIAL SPEC	
D3492-1	0.625	0.394	0.050	M6061T6R0.625	△
D3492-3	0.750	0.582	0.045	M6061T6R0.750	
D3492-5	0.375	0.188	0.045	M6061T6R0.375	
D3492-7	0.500	0.270	0.045	M6061T6R0.500	
D3492-9	0.938	0.750	0.045	M6061T6R1.000	
D3492-11	0.850	0.664	0.045	M6061T6R0.875	
D3492-13	0.750	0.510	0.045	M6061T6R0.750	△

NOTES:

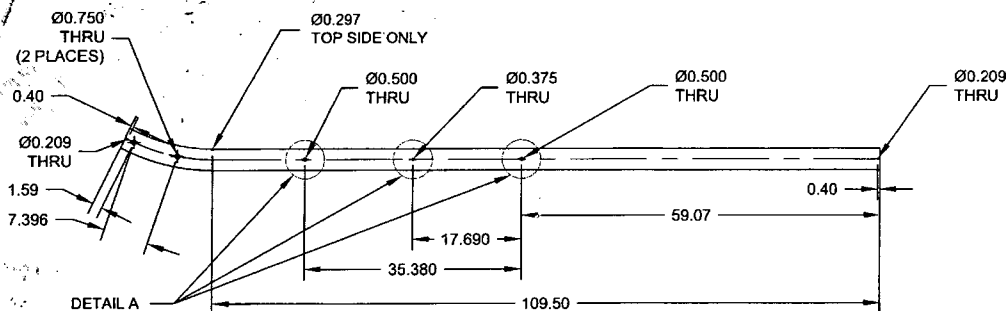
- 1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6R0.000)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

RELEASED
2011-05-30

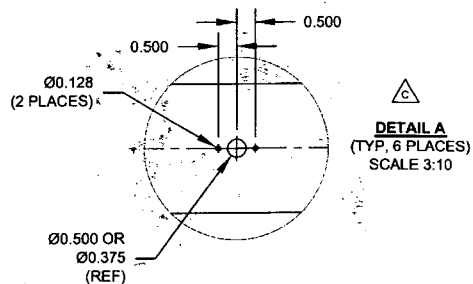
DESIGN	PH	DART AEROSPACE LTD	
DRAWN	A/S	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.	J.F.S.	D3492	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		PLUG	4:1
DATE	11.05.24	<small>COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D3507-1 BENDING/CUTTING DETAIL



D3507-1 DRILLING DETAIL



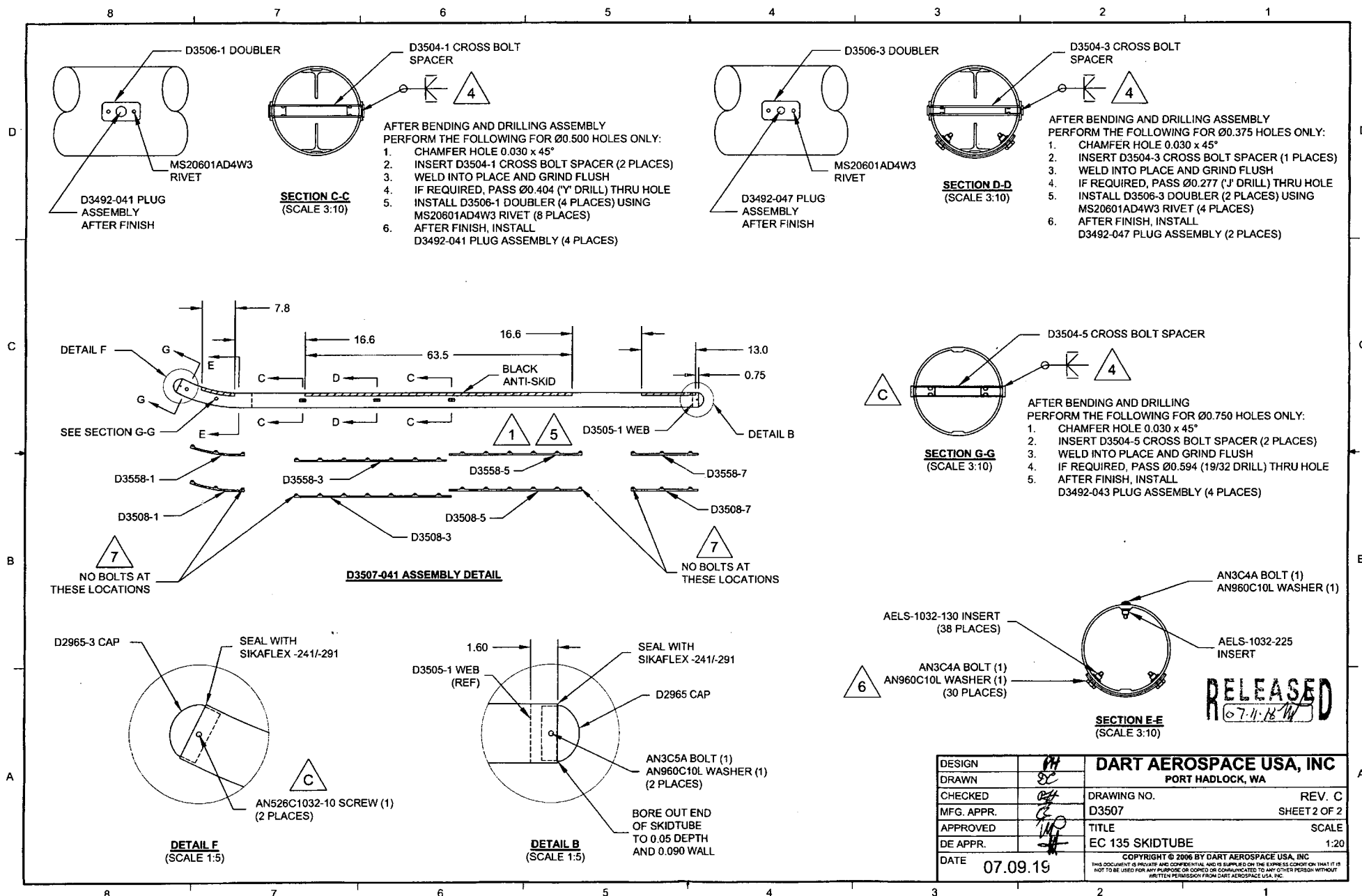
Qty	Part Number	Description
X	D3507-041	SKIDTUBE ASSEMBLY
1	D2962-150	EXTRUSION
1	D2965	CAP
1	D2965-3	CAP
4	D3492-041	PLUG ASSEMBLY
4	D3492-043	PLUG ASSEMBLY
2	D3492-047	PLUG ASSEMBLY
2	D3504-1	CROSS BOLT SPACER
1	D3504-3	CROSS BOLT SPACER
2	D3504-5	CROSS BOLT SPACER
1	D3505-1	WEB
4	D3506-1	DOUBLER
2	D3506-3	DOUBLER
1	D3508-1	WEARPLATE
1	D3508-3	WEARPLATE
1	D3508-5	WEARPLATE
1	D3508-7	WEARPLATE
1	D3558-1	GASKET
1	D3558-3	GASKET
1	D3558-5	GASKET
1	D3558-7	GASKET
38	AELS-1032-130	INSERT
1	AELS-1032-225	INSERT
31	AN3C4A	BOLT
2	AN3C5A	BOLT
2	AN526C1032-10	SCREW
33	AN960C10L	WASHER
12	MS20601AD4W3	RIVET

GENERAL NOTES:

- 1) FINISH:
CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3505-1 WEB. POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3. ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI 005 4.4
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) DIMENSIONS: INCHES UNLESS OTHERWISE NOTED
- 4) WELDING TO BE DONE PER DART QSI 004
- 5) INSERT D3505-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING
- 6) USE DART DRILL TEMPLATE DT8868 TO LOCATE AND DRILL Ø0.297 HOLES (38 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION C-C (38 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/-291.
- 7) DO NOT INSTALL AN3C4A BOLTS AND AN960C10L WASHERS IN INDICATED LOCATIONS

C	ADD D3504-5, FOR SKID GEAR DEFLECTOR; CHANGE FWD CAP BOLT TO AN526C1032-10 SCREW	DC	07.09.19
B	ADD GASKET, CHANGE HARDWARE MAT'L	PH	06.11.01
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	JC		
CHECKED	PH	DRAWING NO.	REV. C
MFG. APPR.	PH	D3507	SHEET 1 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	EC 135 SKIDTUBE	NTS
DATE	07.09.19	COPYRIGHT © 2006 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

RELEASED
07.11.16



5.0 PARTS LIST

Item	Qty -011	Qty -041	Qty -043	Qty -101	Part Number	Description
	X				D135-751-011	SKIDTUBE INSTALLATION
	1	X			D135-751-041	REPLACEMENT SKIDTUBE
			X		D135-751-043	WEARPLATE KIT
				X	D135-751-101	SKIDTUBE EXTENSION KIT
1		1			D3507-041	SKIDTUBE ASSEMBLY
2	4				**BRS8-96/48SZ-M8-W2	CLAMP
3	8				**LN9038-08032	SCREW
4		1			*D2965	CAP
5		1			*D2965-3	CAP
6		2			***AELS-1032-130	INSERT
7		2			***AELS-1032-225	INSERT
8		2			*AN3C5A	BOLT
9		2			*AN960C10L	WASHER
10		2			*AN526C1032-10	SCREW
20A		1	1		*D3508-1	WEARPLATE
20B		1	1		*D3558-1	GASKET
21A		1	1		*D3508-3	WEARPLATE
21B		1	1		*D3558-3	GASKET
22A		1	1		*D3508-5	WEARPLATE
22B		1	1		*D3558-5	GASKET
23A		1	1		*D3508-7	WEARPLATE
23B		1	1		*D3558-7	GASKET
24		38			*AELS-1032-130	INSERT
25	8	30	38		*AN3C4A	BOLT
26	8	30	38		*AN960C10L	WASHER
27	27		2		D3512-1	WEARPLATE
30		1			*AELS-1032-225	INSERT
31		1			*AN3C4A	BOLT
32		1			*AN960C10L	WASHER
40		4			*D3492-041	PLUG ASSEMBLY
41		4			***NAS1611-010	O-RING
42		2			*D3492-047	PLUG ASSEMBLY
43		2			***NAS1611-007	O-RING
44		4			*D3506-1	DOUBLER
45		8			*MS20601AD4W3	RIVET
46		2			*D3506-3	DOUBLER
47		4			*MS20601AD4W3	RIVET
48		4			*D3492-043	PLUG ASSEMBLY
49		4			***NAS1611-013	O-RING
50				1	D3510-041	INSERT ASSEMBLY
51				2	***AELS-1032-130	INSERT
52				6	***AELS-1032-225	INSERT
53				2	***ALS4-428-165	INSERT
54				2	AN4C7A	BOLT
55				2	AN960C416L	WASHER
56				2	AN3C4A	BOLT
57				8	AN3C7A	BOLT
58				10	AN960C10L	WASHER

* PART IS INCLUDED WITH D3507-041 SKIDTUBE ASSEMBLY

** TO BE SUPPLIED BY CUSTOMER, LISTED AS REFERENCE ONLY

*** DENOTES PART IS INCLUDED WITH ASSEMBLY ABOVE